

Work Order ID 64776

Friday, December 17, 2010 7:49:34 AM

Page 1

Item ID: D2151

Accept

Setup Start

Revision ID:

Stop

Item Name: Packer Doubler, Hinge

Start Date: 12/16/2010 Start Qty: 30.00

Cust Item ID:

Required Date: 1/19/2011 Req'd Qty: 30.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10/2/17

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2151

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2151

☐ Dwg Rev: B

☐ Prog Rev: B

☐ 2-

Deburr if necessary

B 11-1-3

34

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 11-1-3

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Silver 103

count
x34

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D2151

Accept



Setup Start



Revision ID:

Stop



Item Name: Packer Doubler, Hinge

Start Date: 12/16/2010 Start Qty: 30.00



Cust Item ID:

Required Date: 1/19/2011 Req'd Qty: 30.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Debur								
	<i>n/AE</i>								
140		0.00							
	Chemical Conversion Coat per QSI005 4.1								
HandFinish	Memo	0.00							
Hand Finishing									
	<i>=> H 11/01/04</i>					<i>34</i>	<i>8</i>		
150		0.00							
	White Gloss(Ref.4.3.5.1) per QSI005 4.3-Alum								
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <i>3:20</i>								
	<i>3:00</i> FINISH TIME: <i>3:50</i>								
	<i>OVEN TEMPERATURE:</i>								
	<i>3:50</i>								
	<i>34 BL 10-01-04</i>								

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Page 3

Item ID:	D2151	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Packer Doubler, Hinge					
Start Date:	12/16/2010	Start Qty:	30.00	Cust Item ID:		
Required Date:	1/19/2011	Req'd Qty:	30.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							

Quality Control

170	Identify as per dwg & Stock Location: <u>006</u>	0.00							
Packaging	Memo	0.00							

Packaging

180	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							

Quality Control

Handwritten signature and date: 11/01/06

Handwritten signature and date: 11/01/06

Handwritten initials and date: 11-01-06

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Friday, December 17, 2010 7:49:38 AM

Page 1

Work Order ID: 64776

Parent Item: D2151

Parent Item Name: Packer Doubler, Hing



Start Date: 12/16/2010

Required Date: 1/19/2011

Start Qty: 30.00

Required Qty: 30.00

Comments:

IPP ☐ C100.10.23 ☐ Re-format (mpp 2101) ☐ EC ☐
 IPP Rev:D 06-04-28 Manufactured on Water Jet JLM
 IPP Rev:E 06-11-24 As per Rev B JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.040 Purchased No 110 sf 219.9400 0.035 1.105263



2024-T3 .040 sheet



1811-1-3

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	30.2	
114415	30.2	
MAT22	189.74	
110305	21.93	
111786	9.66	
112291	28.25	
112331	52	
113162	77.9	

114415

34

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DART AEROSPACE LTD		Work Order:	64774
Description: Packer		Part Number:	D2151
Inspection Dwg: D2151 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	.100	*		V 1B02	
Ø0.171	+0.005/-0.000	.173	*		V	
0.231	+/-0.010	.228	✓		V	
1.217	+/-0.010	1.215	✓		V	
2.194	+/-0.010	2.204	✓		V	
2.300	+/-0.010	2.309	✓		V	
1.560	+/-0.010	1.565	✓		V	
0.250	+/-0.010	.253	✓		V	
1.328	+/-0.010	1.328	✓		V	
0.342	+/-0.010	.342	✓		V	
0.740	+/-0.010	.744	✓		V	
2.050	+/-0.010	2.049	✓		V	
0.040	+/-0.010	.043	✓		V	

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 10-1-3	Date: 11/01/03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	06.11.24	Dwg Revision revised	KJ/JLM	BE

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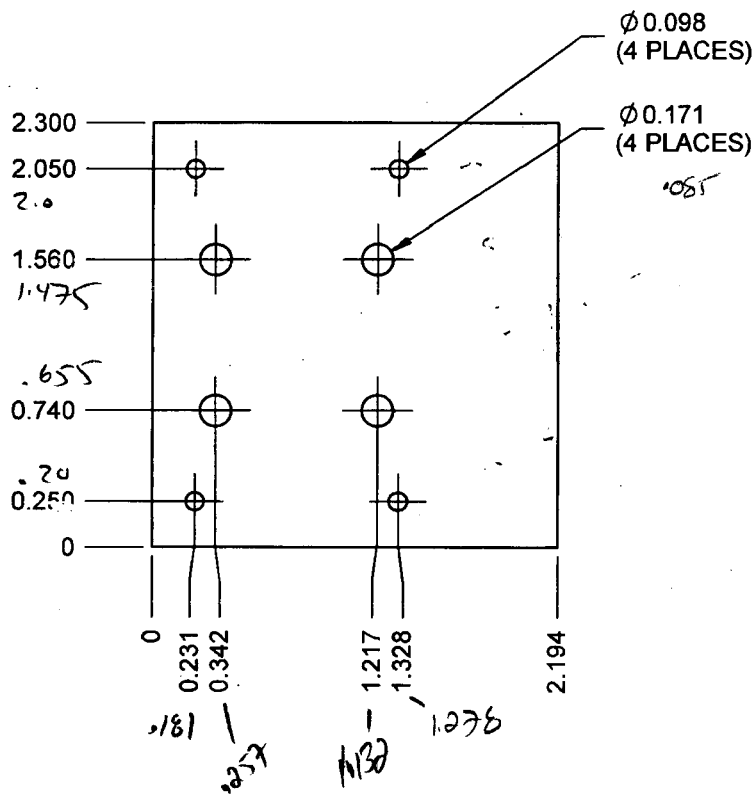
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DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D2151	REV. B SHEET 1 OF 1
DATE 06.10.13		TITLE PACKER	SCALE 1:1
REV	DATE	DESCRIPTION	
A	95.05.01	NEW ISSUE	
B	06.10.13	UPDATE DRAWING	

RELEASED06.11.20 **[Signature]****D2151 PACKER**

UNCONTROLLED
5
6-17-74
R/S 10-12-17

NOTES:

- 1) MATERIAL: ALUMINUM 2024-T3 SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D2151" USING FINE POINT PERMANENT INK MARKER

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